

Date: Tuesday, 1/23/2007 7:31:05 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 30373	
Estimate Number : 10584	
P.O. Number : N/A	Part Number : D1048
This Issue : 1/23/2007 S.O. No. : N/A	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29769	Material : N/A
Written By : <u>JA</u>	Due Date : 2/10/2007 Qty: 50 Um: Each
Checked & Approved By : <u>JA 07.01.23</u>	
Comment : Est: B 02.02.22 Re-format NG	
Est Rev: C Now on Waterjet 06-12-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s)  
 304/316 .063 Sheet  
 Batch: M101873

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D1048  
 Dwg Rev: A  
 Prog Rev: A  
 2-Deburr if necessary

SAD 07/01/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/01/28

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M07/01/29 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

FF 07-02-09 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/02/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:31:05 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30373

Part Number: D1048

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF

07-02-09

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD

07/02/09

50

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m100760

FL/YL

07/02/13

50

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ce 7/2/20

07/02/22

50

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st

Ce 7/2/20

50

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
97/09/02 REV

NOTES:

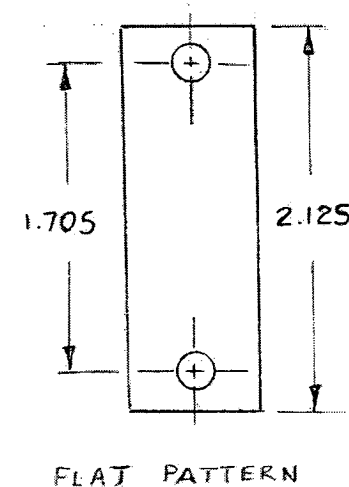
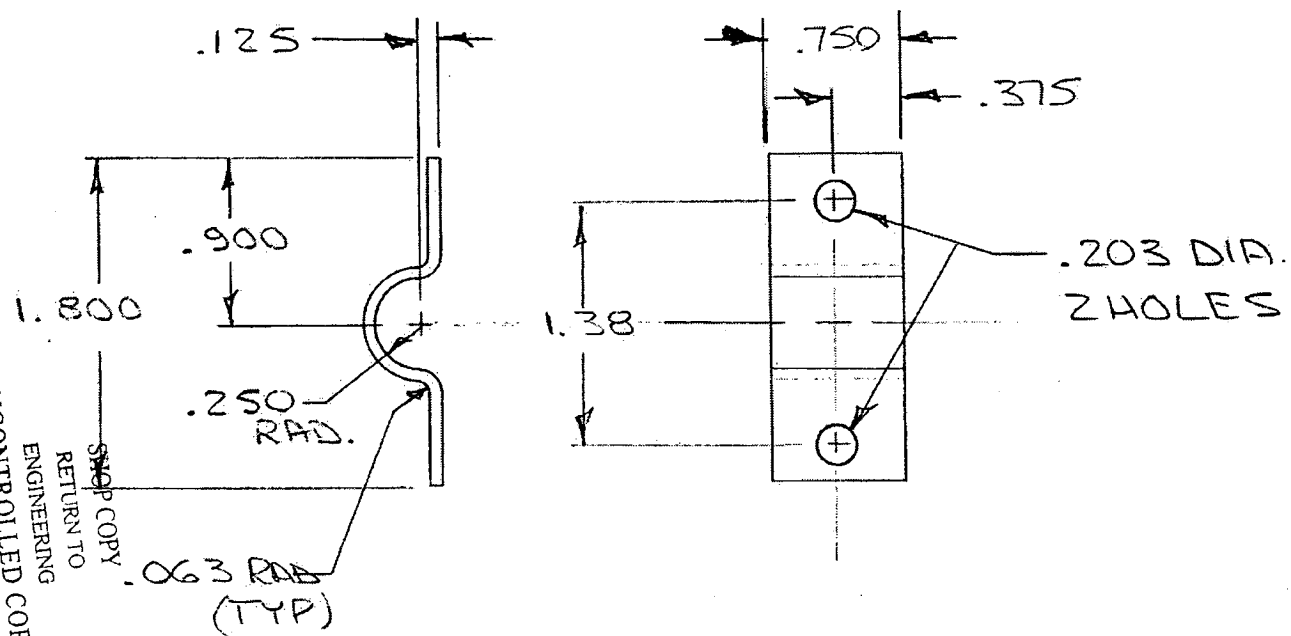
1) MATERIAL

STAINLESS STEEL

T304#2B .062 THICK

2) FINISH : POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)  
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



NO. 30313  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
RF		DRAWN			BASIC CODE		CONTRACT NO.				DART AERO ACCESSORIES INC. VANCOUVER CANADA	
		APPROVED			D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK		DATE 5/1/97					
		DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES 88-MS20430RD 88-MS20438AD		DESIGN BRADLEY		STRESS		TITLE CLAMP	
			GENERAL				CHECKED				CODE D1048	
			LIMITS				CLIENT				REV. A	
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. S - 7742 5. HOLES PER AND 10207		1. TOLERANCES — .XX ± .030 2. ANGLES .XX ± .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005						SCALE 1:1 SHT 1 OF 1	
			REPORT ALL DISCREPANCIES — DO NOT SCALE									

D1048

A

2

1

